

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019967**Date Inspected:** 15-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Xu Xian Ping.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG BAY 5 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**BAY 6**

Flux Cored Arc (FCAW) welding of welds joint CB3002J-002-045, And Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4b-F.

**BAY 7**

Submerged Arc Welding (SAW) welding of welds joint CB3003C-019-002(CB19, BAY 7), and Welder is identified as 054458. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) welding of welds joint X4253A-003-001, and Critical Welding Repair Report (CWR) B-CWR2030, Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Xu

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Hai Yang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G (1F)-FCM-Repair.

SMAW welding of welds joint X4253A-001-001, and Critical Welding Repair Report (CWR) B-CWR2028, Welder is identified as 053753,057795. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G (1F)-FCM-Repair.

Flux Cored Arc (FCAW) welding of welds joint DP3168-001-123, And Welder is identified as 204342, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2232-TC-U4b-F-2.

FCAW welding of welds joint DP3168-001-099, And Welder is identified as 215689, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-4132.

BAY 8

Flux Cored Arc (FCAW) welding of welds joint BK004A4-064-040/041, And Welder is identified as 054459, 500405, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06965

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as CB19 weld. The weld designations reviewed are as follows.

1. X4253B-005-001
2. X4253B-006-001
3. X4253B-001-001
4. X4253B-002-001
5. X4253F-001-001
6. X4253F-002-001

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

---